

Work Order ID 86087

June-20-12 12:58:35 PM

86087

Page 1

Item ID: D212-722-013

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Dzus Rail Brace

Stop *NS2*

Start Date: 20/06/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 04/07/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/20 Tooling:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr Revision Nbr

DSI 9476

A

100

100

DC

Document Control

Memo

Photocopie DSI 9476 and labels per PPP D212-722-013

DAS 16 17/08/09

CHG001

MLJ 12-8-8

(2)

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

2

12/08/08

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

DAS 16 17/08/09

(2)

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

Work Order ID 86087

June-20-12 12:58:35 PM

86087

Page 2

Item ID: D212-722-013

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Dzus Rail Brace

Start Date: 20/06/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 04/07/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00

130

Packaging

Memo

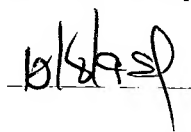
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Packaging

Identify and pack for shipping as per PPP D212-722-013

Location: 124

PPP rev: _____



140

QC21- Final Inspection - Work Order Release

0.00

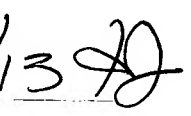
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QC

Memo

0.00

Quality Control

12/8/13 
MLJ 12/08/09

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Picklist Print

June-20-12 12:58:38 PM

Page 1

Work Order ID: 86087

86087

Parent Item: D212-722-013

D212-722-013

Parent Item Name: Dzus Rail Brace



Start Date: 20/06/2012

Required Date: 04/07/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP revA 11.06.21 new issue EC verified by:DD

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|---|--------------|---------------|----------------|---|
| D3986-1 | | Manufactured | No | | | 110 | Each | 11.0000 |  | 2 | | |  |

D3986-1

Angle

**

JB

Location

Loc Qty

Loc Code

ST081

11

84644

11

D3986-3

Manufactured No

110

Each

8.0000

84644

4

**

JB



12/08/08

Brace

Location

Loc Qty

Loc Code

ST103

8

71094

8

71094

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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WORK ORDER

NO. 860081 MC

12/06/20

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D212-722 REV. A

REF. TCCA STC: SH05-11

REF. FAA STC: SR02091NY

REF. EASA.IM.R.S.01181

The purpose of the Service Instruction is to provide instructions for the installation of the D212-722-013 Dzus Rail Brace Kit which has been developed to provide a fastening method for the center dzus rail when the D212-722-011 Avionics Riser Console is installed. The D212-722-013 kit has been added to all D212-722-011 kits at CHG 003 or later.

If the aircraft pedestal has been removed from the aircraft follow the instructions in Option 1. If the pedestal has not been removed from the aircraft follow instructions in Option 2 (Sheet 2).

The maximum weight of equipment installed in front of the D212-722-011 Avionics Riser Console using the D212-722-013 Kit is 40 lbs.

Option 1 - Install D212-722-013 Dzus Rail Brace Kit as follows if pedestal has been removed from aircraft:

Note: The existing PR35 center dzus rails will need to be removed and re-worked to the correct length in order to install the D212-722-013 Dzus Rail Brace Kit.

CAUTION: Alignment of the parts is critical to a successful installation. It is strongly recommended that the parts be clamped together before drilling and then clecoed together before riveting.

- 1) Remove the rivets securing the existing center PR35 dzus rails.
- 2) Remove the existing center dzus rail braces.
- 3) Clamp the D3986-1 angle, D3986-3 braces and PR35 dzus rail together as shown in Figure 1 (Sheet 3). The D3986-3 braces should be approximately centered between the existing dzus rails.
- 4) Install blanking plates (Figure 5, Sheet 7) to position the PR35 dzus rails in the correct position.
- 5) Transfer drill 9x $\varnothing 0.129$ (#30 drill) holes from PR35 dzus rail thru D3986-3 braces. See Figure 2, (Sheet 4), Note 1.
- 6) Deburr holes and reassemble using clecos.
- 7) Transfer drill 4x $\varnothing 0.129$ (#30 drill) holes from D3986-3 braces to D3986-1 angle. See Figure 2, (Sheet 4), Note 2.
- 8) Deburr holes and reassemble using clecos.
- 9) Transfer drill 4x $\varnothing 0.129$ (#30 drill) holes from aircraft pedestal to D3986-3 braces. See Figure 2, (Sheet 4), Note 3.
- 10) Deburr holes, dimple D3986-3 brace and aircraft pedestal and reassemble using clecos.
- 11) Transfer drill 4x $\varnothing 0.129$ (#30 drill) holes from D3986-1 angle to aircraft pedestal. See Figure 2, (Sheet 4), Note 4.
- 12) Deburr holes, dimple D3986-1 angle and aircraft pedestal and reassemble using clecos.
- 13) Re-install blanking plates (Figure 5, Sheet 7) and verify correct position of PR35 dzus rails.
- 14) Install MS20470AD4 and MS20426AD4 rivets as shown in Figure 2 (Sheet 4) in the same order as the holes were drilled, maintaining the PR35 dzus rail position.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *D. Shepherd*
D. SHEPHERD (DE # 02)

DATE: 11.06.01
CERT. NO.: SH05-11
ISSUE NO.: 1

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|------------|-------------|----|----------|
| A | NEW ISSUE | | 11.06.01 |
| REV. | DESCRIPTION | BY | DATE |
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| DRAWN | | | |
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| DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWING NO. DSI 9476 | REV. A SHEET 1 OF 7 |
| TITLE DZUS RAIL BRACE KIT | SCALE NTS |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Option 2 - Install D212-722-013 Dzus Rail Brace Kit as follows if pedestal has not been removed from aircraft:

Note: The existing PR35 center dzus rails will need to be removed and re-worked to a correct length in order to install the D212-722-013 Dzus Rail Brace Kit.

CAUTION: Alignment of the parts is critical to a successful installation. It is strongly recommended that the parts be clamped together before drilling and then clecoed together before riveting.

- 1) Remove the rivets securing the PR35 center dzus rails from the existing dzus rail brace. Remove dzus rail.
- 2) Without removing it, trim the existing left dzus rail brace, as shown in Figure 4 (Sheet 6). Trim the existing right dzus rail brace 2.25" longer. See Note 1 Figure 4 (Sheet 6).
- 3) Trim D3986-3 braces so that when matched with the existing dzus rail braces the original D3986-3 length is maintained.
- 4) Clamp and cleco the D3986-1 angle, the trimmed D3986-3 braces and PR35 dzus rail together as shown in Figure 3 (Sheet 5).
- 5) Install blanking plates (Figure 5, Sheet 7) to position the PR35 dzus rails in the correct position.
- 6) Transfer drill $\varnothing 0.129$ (#30 drill) the necessary holes (4 typ) from PR35 dzus rail thru D3986-3 braces. See Figure 3, (Sheet 5), Note 1.
- 7) Deburr holes and reassemble using clecos.
- 8) Transfer drill 4x $\varnothing 0.129$ (#30 drill) holes from D3986-3 braces to D3986-1 angle. See Figure 3, (Sheet 5), Note 2.
- 9) Deburr holes and reassemble using clecos.
- 10) Transfer drill 4x $\varnothing 0.129$ (#30 drill) holes from D3986-1 angle to aircraft console. See Figure 3, (Sheet 5), Note 3.
- 11) Deburr holes, dimple D3986-1 angle and aircraft console and reassemble using clecos.
- 12) Re-install blanking plates (Figure 5, Sheet 7) and verify correct position of PR35 dzus rails
- 13) Install MS20470AD4 and MS20426AD4 rivets as shown in Figure 3 (Sheet 5) in the same order as the holes were drilled, maintaining the PR35 dzus rail position.

WEIGHT AND BALANCE

Compliance with this DSI has no effect on the aircraft weight and balance.

PARTS LIST






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|--------------|--------------|---------------------|
| X | D212-722-013 | DZUS RAIL BRACE KIT |
| 1 | D3986-1 | ANGLE |
| 2 | D3986-3 | BRACE |

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DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

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BY: 
D. SHEPHERD (DE # 02)

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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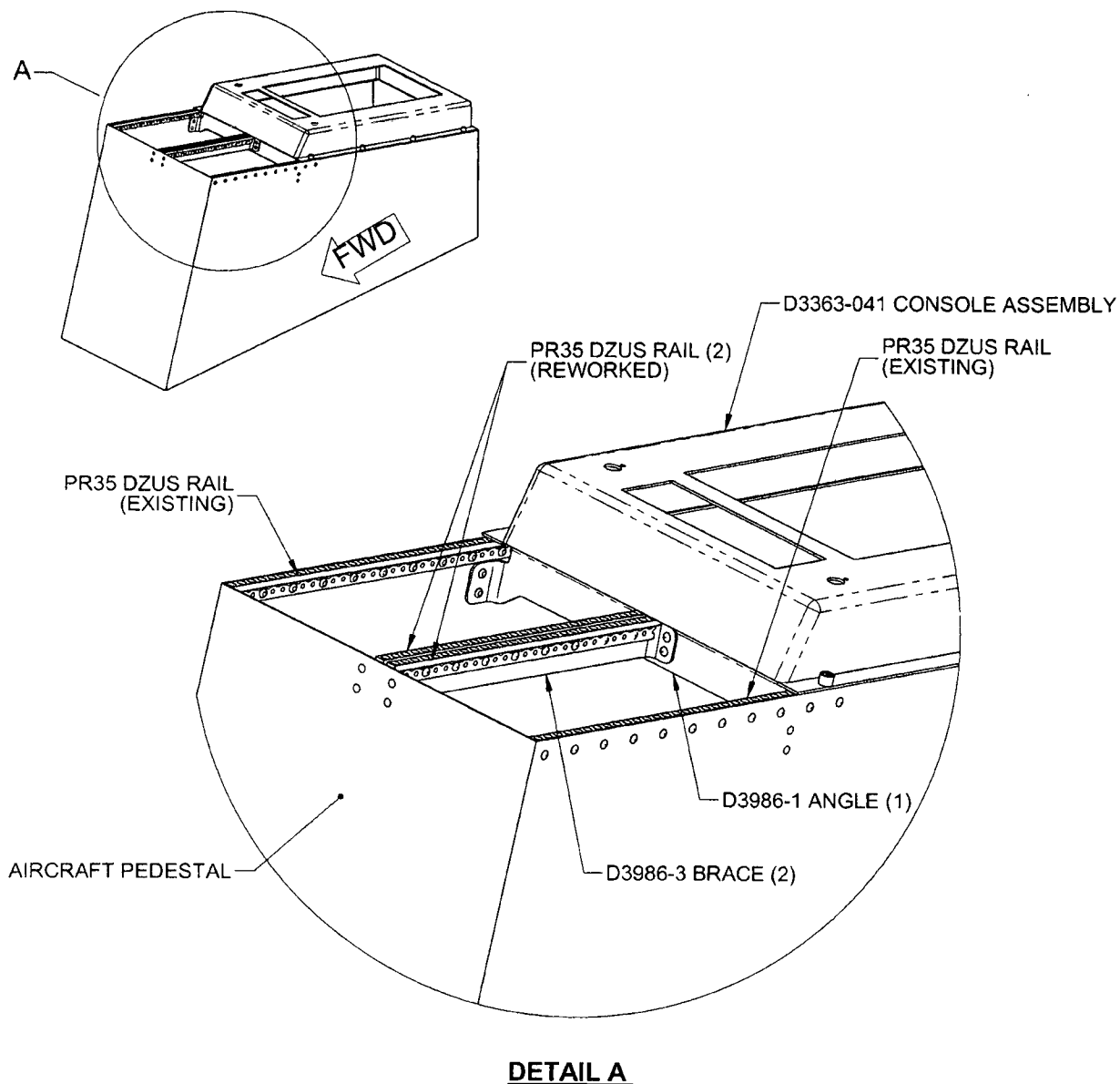


FIGURE 1: D212-722-013 DZUS RAIL BRACE INSTALLATION

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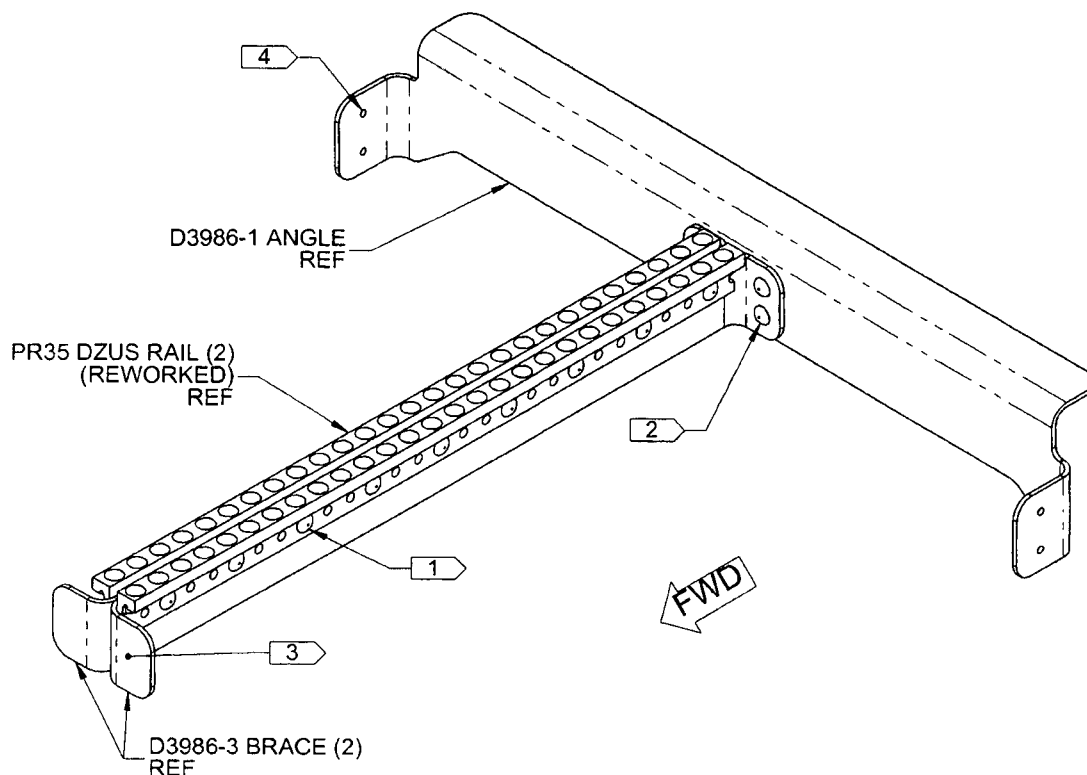
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NOTE: Date & initial all entries



- 1) CONFIRM THAT DZUS RAIL AND BRACE ARE IN CORRECT POSITION AND TRANSFER DRILL $\varnothing 0.129$ (#30 DRILL) FROM PR35 DZUS RAIL THRU D3986-3 BRACES. INSTALL MS20470AD4 RIVETS, 9 PL TYP
- 2) CONFIRM THAT DZUS RAIL AND BRACE ARE IN CORRECT POSITION AND TRANSFER DRILL 4X $\varnothing 0.129$ (#30 DRILL) HOLES FROM D3986-3 BRACE TO D3986-1 ANGLE. INSTALL MS20470AD4 RIVETS, 4 PL
- 3) CONFIRM THAT DZUS RAIL AND BRACE ARE IN CORRECT POSITION AND TRANSFER DRILL 4X $\varnothing 0.129$ (#30 DRILL) FROM AIRCRAFT CONSOLE TO D3986-3 BRACES. DIMPLE D3986-3 BRACES AND INSTALL MS20426AD4 RIVETS, 4 PL.
- 4) CONFIRM THAT DZUS RAIL AND BRACE ARE IN CORRECT POSITION AND TRANSFER DRILL 4X $\varnothing 0.129$ (#30 DRILL) FROM D3986-1 ANGLE TO AIRCRAFT CONSOLE. DIMPLE D3986-1 ANGLE AND AIRCRAFT CONSOLE AND INSTALL MS20426AD4 RIVETS, 4 PL

FIGURE 2: D212-722-013 DZUS RAIL BRACE INSTALLATION - OPTION 1
(PEDESTAL REMOVED FROM AIRCRAFT)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE #02)

DATE: 11.06.01
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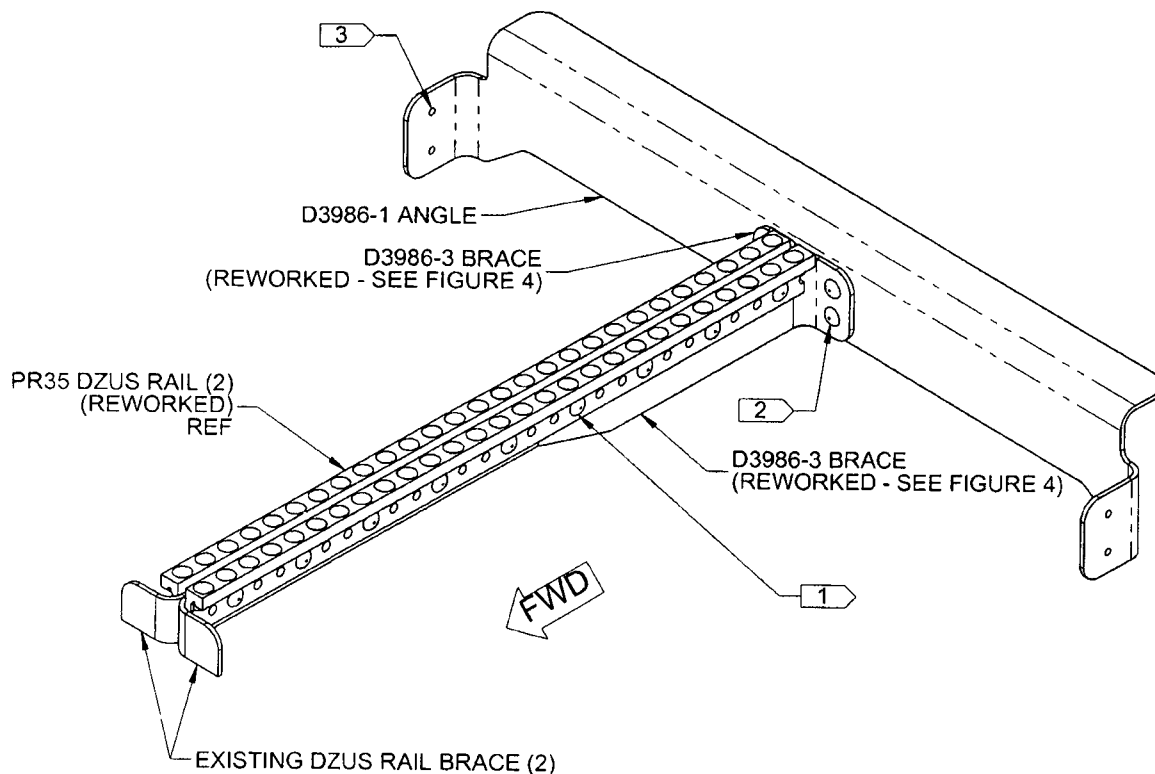
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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



- 1) CONFIRM THAT DZUS RAIL AND BRACE ARE IN CORRECT POSITION AND TRANSFER DRILL (4 PL TYP) $\varnothing 0.129$ (#30 DRILL) FROM PR35 DZUS RAIL THRU D3986-3 BRACES. INSTALL MS20470AD4 RIVETS, 9 PL TYP
- 2) CONFIRM THAT DZUS RAIL AND BRACE ARE IN CORRECT POSITION AND TRANSFER DRILL 4X $\varnothing 0.129$ (#30 DRILL) HOLES FROM D3986-3 BRACE TO D3986-1 ANGLE. INSTALL MS20470AD4 RIVETS, 4 PL
- 3) CONFIRM THAT DZUS RAIL AND BRACE ARE IN CORRECT POSITION AND TRANSFER DRILL 4X $\varnothing 0.129$ (#30 DRILL) FROM D3986-1 ANGLE TO AIRCRAFT CONSOLE. DIMPLE D3986-1 ANGLE AND AIRCRAFT CONSOLE AND INSTALL MS20426AD4 RIVETS, 4 PL

FIGURE 3: D212-722-013 DZUS RAIL BRACE INSTALLATION - OPTION 2
(PEDESTAL NOT REMOVED FROM AIRCRAFT)

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DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
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| MFG. APPR. | N/A | DSI 9476 | SHEET 5 OF 7 |
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| DE APPR. | <i>[Signature]</i> | DZUS RAIL BRACE KIT | NTS |
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Dart Aerospace Ltd

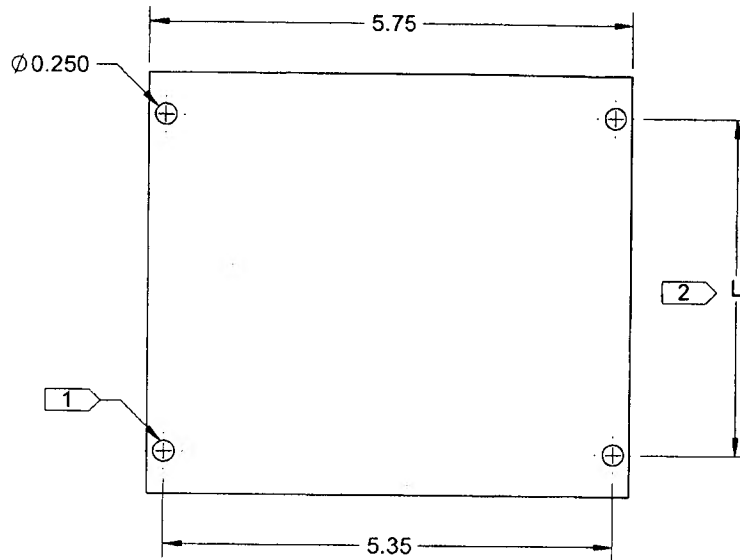
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



- 1) INSTALL DZUS FASTENERS, 4 PL TYP
- 2) DIMENSION "L" IS MIN 4". MUST BE DIVISIBLE BY 0.375

FIGURE 5: BLANKING PLATE

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: [Signature]
D. SHEPHERD (DE # 02)

DATE: 11.06.01
CERT. NO.: SH05-11
ISSUE NO.: 1

| | | | |
|------------|--------------------|--|--------------|
| DESIGN | <u>[Signature]</u> | DART AEROSPACE LTD | |
| DRAWN | <u>[Signature]</u> | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | <u>[Signature]</u> | DRAWING NO. | REV. A |
| MFG. APPR. | N/A | DSI 9476 | SHEET 7 OF 7 |
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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Option 2 - Install D212-722-013 Dzus Rail Brace Kit as follows if pedestal has not been removed from aircraft:

REFERENCE ONLY

Note: The existing PR35 center dzus rails will need to be removed and re-worked to a correct length in order to install the D212-722-013 Dzus Rail Brace Kit.

CAUTION: Alignment of the parts is critical to a successful installation. It is strongly recommended that the parts be clamped together before drilling and then clecoed together before riveting.

- 1) Remove the rivets securing the PR35 center dzus rails from the existing dzus rail brace. Remove dzus rail.
- 2) Without removing it, trim the existing left dzus rail brace, as shown in Figure 4 (Sheet 6). Trim the existing right dzus rail brace 2.25" longer. See Note 1 Figure 4 (Sheet 6).
- 3) Trim D3986-3 braces so that when matched with the existing dzus rail braces the original D3986-3 length is maintained.
- 4) Clamp and cleco the D3986-1 angle, the trimmed D3986-3 braces and PR35 dzus rail together as shown in Figure 3 (Sheet 5).
- 5) Install blanking plates (Figure 5, Sheet 7) to position the PR35 dzus rails in the correct position.
- 6) Transfer drill $\varnothing 0.129$ (#30 drill) the necessary holes (4 typ) from PR35 dzus rail thru D3986-3 braces. See Figure 3, (Sheet 5), Note 1.
- 7) Deburr holes and reassemble using clecos.
- 8) Transfer drill 4x $\varnothing 0.129$ (#30 drill) holes from D3986-3 braces to D3986-1 angle. See Figure 3, (Sheet 5), Note 2.
- 9) Deburr holes and reassemble using clecos.
- 10) Transfer drill 4x $\varnothing 0.129$ (#30 drill) holes from D3986-1 angle to aircraft console. See Figure 3, (Sheet 5), Note 3.
- 11) Deburr holes, dimple D3986-1 angle and aircraft console and reassemble using clecos.
- 12) Re-install blanking plates (Figure 5, Sheet 7) and verify correct position of PR35 dzus rails
- 13) Install MS20470AD4 and MS20426AD4 rivets as shown in Figure 3 (Sheet 5) in the same order as the holes were drilled, maintaining the PR35 dzus rail position.

WEIGHT AND BALANCE

Compliance with this DSI has no effect on the aircraft weight and balance.

PARTS LIST

| QTY. -013 | PART NUMBER | DESCRIPTION |
|--------------|--------------|---------------------|
| X | D212-722-013 | DZUS RAIL BRACE KIT |
| 1 | D3986-1 | ANGLE |
| 2 | D3986-3 | BRACE |

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: D. SHEPHERD (DE # 02)

DATE: 11.06.01
CERT. NO.: SH05-11
ISSUE NO.: 1

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| CHECKED | | DRAWING NO. | REV. A |
| MFG. APPR. | N/A | DSI 9476 | SHEET 2 OF 7 |
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